



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5522-041
Job Sheet 188576



00854

Part No: D5522-041

Job Qty: 4 ea

Part Name: Oil Drain Valve Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/19

Job Tracking No:

Due Date: 1/25/19

Created By: Jesse White

Type: SOLD

Description:

Note: D5522 REV.C IPP rev:A RQ 17.04.12 Verified by: DD IPP REV:B 17.05.12 AS PER DWG REV.A DD
VERF:JFS IPP REV:C 17.09.19 AS PER DWG REV.C DD VERF:JFS IPP REV:D 17.11.17 MODIFY
PROCESS AND BOM AS PER INTUITIVE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	1/25/19	1/25/19	0.00	0.00	Start Up Small Fab-4		DAS 58 DAS 58 MAR 08 2019
140	Small Fab	4 pcs	1/25/19	1/25/19	0.00	4.75	Small Fab-4		DAS 58 MAR 08 2019
150	QC	4 pcs	1/25/19	1/25/19	0.00	0.00	QC5		DAS 58 MAR 08 2019
160	Packaging	4 pcs	1/25/19	1/25/19	0.00	0.00	Packaging3-2	57166	DAS 58 MAR 11 2019
170	QC21-SA	4 Ea	1/25/19	1/25/19	0.00	0.00	QC21		DAS 58 MAR 11 2019

Part Op 140 - ***BEFORE ASSEMBLY VERIFY IF THE PART IS CLEAN INSIDE*** Assemble D5522-041 as per Dwg D5522, Descriptions: note 8-9-10,11,12. *** 1- INSTALL D5527-1 AS PER DWG WITH PERMATEX THREAD SEALANT. TORQUE AS PER DWG NOTE 8. BATCH: m13145 VERIFY TORQUE BY: 58 *****BEFORE INSTALLING AN814-4J PLUG AND D5530-1 FITTING REMOVE ORINGS (SCRAP THEM) AND REPLACE THEM WITH M83248/1-012 PACKING***** 2- INSTALL AN814-4J PLUG, D5370-1 AND D5530-1 FITTING AS PER DWG WITH OIL LUB 2380. TORQUE AS PER DWG NOTE 9. 2380 BATCH: m138072 VERIFY TORQUE BY: 58 3- LOCKWIRE AS PER DWG, SEE NOTE 10. 4- ATTACH VALVE CAP WITH LANDYARD AS PER DWG NOTE 11. (PICK CBL460 AND CBL1240)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN814-4JL	Plug	4 Ea (1 ea)	90-Start up Operation	506069
CBL-1240	Cable	4 ft (1 ea)	90-Start up Operation	5113791
CBL-460	Loop Sleeve	16 Ea (4 ea)	90-Start up Operation	5148627
D5522-1	Oil Drain Valve Mount	4 Ea (1 ea)	90-Start up Operation	5147261
D5527-1	Oil Drain Valve	8 pcs (2 ea)	90-Start up Operation	5147336
D5530-1	37° Flared Tube Fitting	4 pcs (1 ea)	90-Start up Operation	5145514
D5532-041	Valve Cap Assembly	8 pcs (2 ea)	90-Start up Operation	5145513
M83248/1-012	Packing	8 Ea (2 ea)	90-Start up Operation	50087815
AS3208-06	Packing	4 Ea (1 ea)	90-Start up Operation	5001689
D5370-1	Fitting	4 pcs (1 ea)	90-Start up Operation	5145207

147375
515688

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : _____							

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN814-4JL	4	17	0
	AS3208-06	4	152	0
	CBL-1240	4	207	0
	CBL-460	16	358	0
	D5370-1	4	22	0
	D5522-1	4	0	0
	D5527-1	8	6	0
	D5530-1	4	10	0
	D5532-041	8	8	0
	M83248/1-012	8	102	0
Part Specifications				
Specifications could not be found.				

Plex 1/11/19 9:06 AM dart.white.jesse

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date : _____		MRB (QSI042) Approval 																																																																					
Description : 		 DART AEROSPACE Container No: S160667 Part: D5522 - 041 Job No: 188576 Serial No/Batch: S160667 Revision: C Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 02/08/19																																																																					
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-ver ☐</td> <td>Cracks ☐</td> <td>Broken/Damaged ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Sev ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td></td> <td></td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td></td> <td></td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> <td></td> </tr> </table>		Environment ☐	No Re-ver ☐	Cracks ☐	Broken/Damaged ☐	Design ☐	Operator ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Doc/Data ☐	Offset/Sev ☐	Cuffs ☐	Contamination ☐	Equip/Tooling ☐	Supplier ☐	Crushing ☐	Countersink ☐	Handling/Pre ☐	Training ☐	Heat Treat ☐	Cut Too Short ☐	Material ☐	Use for Testing ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Internal Transport ☐	Poor Information ☐	Marks/Chatter ☐	Drill Holes ☐	Tribal Knowledge ☐	Rushing ☐			LOA ☐	Product Improvement ☐			Substation ☐	Process Improvement ☐			Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐			<table style="width:100%;"> <tr> <td>Surge ram ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td></td> <td>Outside Dimensions ☐</td> </tr> <tr> <td></td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td></td> <td>Part Incorrect ☐</td> </tr> <tr> <td></td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td></td> <td>Part Moved ☐</td> </tr> <tr> <td></td> <td>Drawing ☐</td> </tr> <tr> <td></td> <td>Finish ☐</td> </tr> <tr> <td></td> <td>Misread ☐</td> </tr> <tr> <td></td> <td>Turning Sequence ☐</td> </tr> </table>		Surge ram ☐	Positioned Wrong ☐		Outside Dimensions ☐		Over/Under tolerance ☐		Part Incorrect ☐		Part Lost/Missing ☐		Part Moved ☐		Drawing ☐		Finish ☐		Misread ☐		Turning Sequence ☐
Environment ☐	No Re-ver ☐	Cracks ☐	Broken/Damaged ☐																																																																				
Design ☐	Operator ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐																																																																				
Doc/Data ☐	Offset/Sev ☐	Cuffs ☐	Contamination ☐																																																																				
Equip/Tooling ☐	Supplier ☐	Crushing ☐	Countersink ☐																																																																				
Handling/Pre ☐	Training ☐	Heat Treat ☐	Cut Too Short ☐																																																																				
Material ☐	Use for Testing ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐																																																																				
Internal Transport ☐	Poor Information ☐	Marks/Chatter ☐	Drill Holes ☐																																																																				
Tribal Knowledge ☐	Rushing ☐																																																																						
LOA ☐	Product Improvement ☐																																																																						
Substation ☐	Process Improvement ☐																																																																						
Past Expiry Date ☐	Manufacturing Process ☐																																																																						
Misidentified ☐	Past Due ☐																																																																						
Surge ram ☐	Positioned Wrong ☐																																																																						
	Outside Dimensions ☐																																																																						
	Over/Under tolerance ☐																																																																						
	Part Incorrect ☐																																																																						
	Part Lost/Missing ☐																																																																						
	Part Moved ☐																																																																						
	Drawing ☐																																																																						
	Finish ☐																																																																						
	Misread ☐																																																																						
	Turning Sequence ☐																																																																						
OTHER : _____		_____																																																																					